

Work Order ID 66935

Thursday, March 03, 2011 8:32:47 AM



Page 1

Item ID: D3537-1

Accept



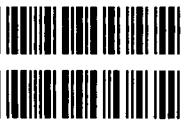
Setup Start



Revision ID:

Item Name: Wearpad

Stop



Start Date: 3/3/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:



Date: 11-03-3 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr	
D3537	Rev C	

100



FLOW WATER JET

Waterjet

Memo

0.00

Bil-3-7

FLOW CNC Waterjet

304 .063

1-Cut as per Dwg D3537 □ Dwg Rev: C □ Prog Rev: C □ 2-Deburr
if necessary

(50)

110



QC2- Inspect parts off machine FAI/FAIB

0.00

Bil-3-7

QC

Memo

0.00

Quality Control

120



QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

8 11/03/07

Counter

X5Z

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Customer:

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Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



Brake NC

Operation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

NC BRAKE

0.00

Memo

Brake NC

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.□2-
Identify as D3537-1

140



Large Fab

Large Fab

0.00

Memo

0.00

Large Fab

Qty Description Batch □ A/R 2059B Hardcoat
 □ 1-Weld as per Dwg D3537 using Jig DT 8210 □ 2-Remove any
weld that penetrated through Wearpad if necessary

150



QC

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

Quality Control

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Du(04/01)

170



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

M 115108

0.00

Memo

START TIME:

1:20

OVEN TEMPERATURE:

FINISH TIME:

1:50

52. BR 11-4-6.

180



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

52 φ M 11104106

W/O:		WORK ORDER CHANGES					
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Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



Packaging

Identify as per dwg & Stock Location:

FR17

0.00

52

BL 11-4-7.

Packaging

Memo

0.00

200



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/4/11

11/11-04-7

(52)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Thursday, March 03, 2011 8:32:52 AM

Page 1

Work Order ID: 66935



Parent Item: D3537-1



Parent Item Name: Wearpad

Start Date: 3/3/2011

Required Date: 3/11/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 		Purchased	No			100	sf	22.3400	0.106	4.463158	 S.6. B1-3-7		

304/316 Sheet .063

Location	Loc Qty	Loc Code
MAT	22.34	
111323	0	
116623	22.34	116623 (50)

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DART AEROSPACE LTD	Work Order:	66935
Description: Wearpad	Part Number:	D3537-1
Inspection Dwg: D3537 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	11-3-17	Date:	11/03/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	
B	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	
C	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM	<i>[Signature]</i>

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SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

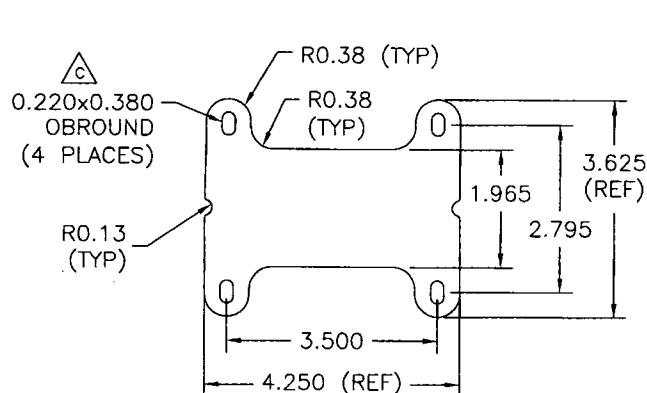
WITHOUT NOTICE

WORK ORDER

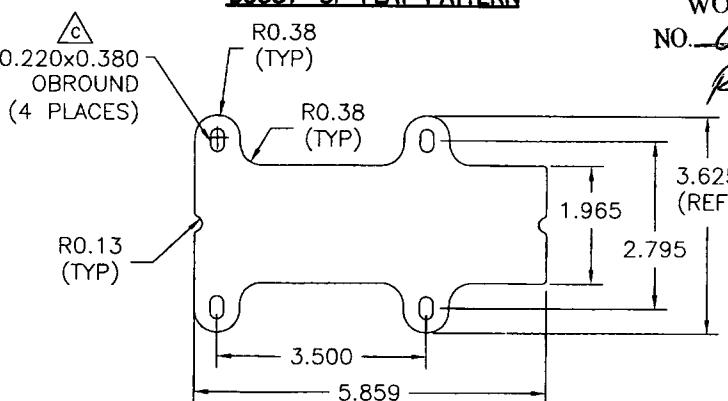
NO. 66985

P111-03-3

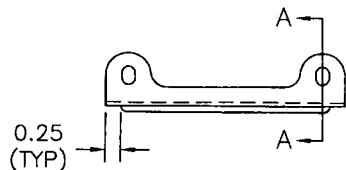
D3537-1F FLAT PATTERN



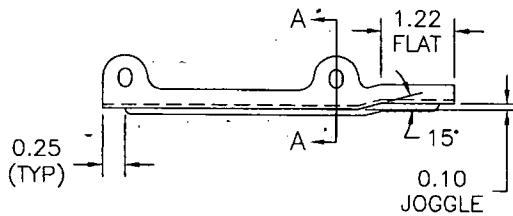
D3537-3F FLAT PATTERN



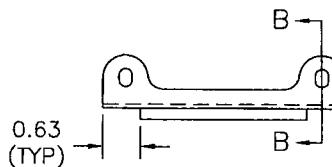
D3537-1 LONGITUDINAL BEND
(MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND
(MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND
(MADE FROM D3537-1F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D3537 DATE 07.04.13 TITLE WEARPAD
		REV. C SHEET 1 OF 1 1:2

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DART AEROSPACE USA, INC.

RELEASED
07.05.08 AM
PC ECLN
962

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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